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RBT400214-9
Job Sheet 178701



JL-7

Part No: RBT400214-9

Job Qty: 8 ea

Part Name: Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/6/18

Job Tracking No:

Due Date: 7/24/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT400214 Rev.7 IPP Rev. A 18.06.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		7/24/18	0.00	0.00	Start Up Machining-4		J.C.L.
120	CNC Vertical Machining	8 pcs		7/24/18	0.00	2.51	MORI NV5000-2		J.C.L.
130	QC	8 pcs		7/24/18	0.00	0.00	QC2 Machining-5		J.C.L. 18-08-30
140	Mill Conv	8 pcs		7/24/18	0.00	1.68	Mill Conv-2		
150	QC	8 pcs		7/24/18	0.00	0.00	QC2 Machining-5		
160	QC	8 pcs		7/24/18	0.00	0.00	QC8 Machining-5		B.A. 18-08-31
170	Packaging	8 pcs		7/24/18	0.00	0.00	Packaging3-2		
180	QC21-SA	8 Ea		7/24/18	0.00	0.00	QC21		had 18.09.04

Part Op 120 - ***Cut blanks to 5.50" long*** 1-Machine as per folio FC 319 FOLIO REV: AA DWG REV:

Descriptions: 7 2-Deburr

140 - 1-Machine as per DWG. 2-Deburr

170 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X00.750	6061T6 Bar 0.500 X 0.750	3.6640 ft (.458 ea)	90-Start up Operation	5089 595

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X00.750	4	20	0

Part Specifications

Specifications could not be found.

Plex 7/24/18 5:59 PM dart.logan.david



Container No: S107251



Part: RBT400214-9

Job No: 178701

Serial No/Batch: S107251

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Date: 08/30/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

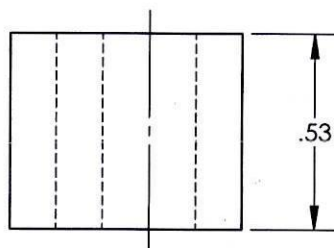
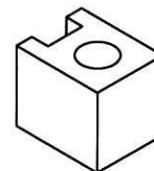
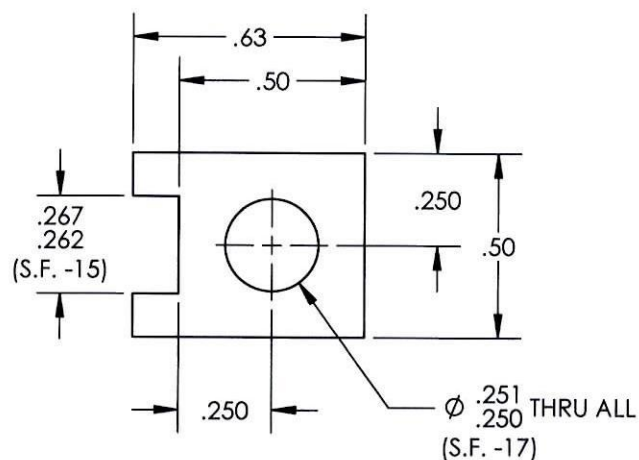
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No.: _____ NCR No.: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence. ☐		OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		-9 CH'D DIM WAS .250 IS .250 +.005/- .000.	2/26/2013	BIM	SE
6		-9 CH'D DIM WAS .500 IS .530.	3/22/2013	BIM	GE
7	16-0240	-9 CH'D DIMS WAS .500 IS .50, WAS .530 IS .53, WAS .250 +.005-.000 S.F. -13 IS .262-.267 (S.F. -15), WAS .625 IS .63, WAS .500 IS .50, WAS Ø.250 IS Ø.250-.251 THRU ALL (S.F. -17).	12/1/2016	DPD	JAG



(-9)

ADAPTER

DART AEROSPACE	
TITLE TRIM TAB BENDING GAUGE	
DWG NO. RBT400214-9	REV 7
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:1	USED ON MODEL
DATE 4/9/2001	BELL 407
SHEET 6 OF 11	